

Monday, May 01, 2017 11:37:59 AM

Page 1

Accept

Setup

Start

NS1

Stop

NS2

Item Name: Crosstube Lug

Start Date: 5/1/2017 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 5/15/2017 **Req'd Qty:** 20.00

20

Customer:

Reference:

DAS

13

9-89

MAY 01 2017

Approvals:

Process Plan:

Date: _____

Tooling:

Date: _____

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	E								
110	Outsourse process - Machining	0.00							DAS 13 8-89
* 110*	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	0.00				20		MAY 0 1 2017	
Ooutsourse process - Machining	Issue P/O to Metec : <u>36153</u>								
	Machine as per dwg								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
* 120*	Packaging	0.40							
Packaging	Memo								
Packaging	Ensure C of C is attach								
130	QC6- All purchased or subcontracted products	0.00							DAS 38 9-89
* 130*	QC	0.00							
Quality Control	Memo					2e			MAY 1 6 2017

Work Order ID 160539

Monday, May 01, 2017 11:37:59 AM

160539

Page 2

Item ID: D3910-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug
Start Date: 5/1/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 5/15/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo <i>N/A</i> <i>DAS 38 9-89</i>	0.00 0.45							
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo <i>N/A</i> <i>DAS 38 9-89</i>	0.00 0.20							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3 Alum Memo <i>N/A</i> <i>DAS 38 9-89</i> START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.71							

Work Order ID 160539

Monday, May 01, 2017 11:37:59 AM

160539

Page 3

Item ID: D3910-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug
Start Date: 5/1/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 5/15/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							DAS 38 9-89
170						20			
QC	Memo	0.20							
Quality Control									MAY 16 2017
180	Identify as per dwg & Stock Location: <u>5125</u>	0.00							
180						20			DAS 6 9-89
Packaging	Memo	0.20							MAY 18 2017
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									17/5/18
QC	Memo	2.00							
Quality Control									DAS 21 9-89

MAY 18 2017

Picklist Print

Monday, May 01, 2017 11:37:58 AM

Page 1

Work Order ID: 160539

160539

Parent Item: D3910-1

D3910-1

Parent Item Name: Crosstube Lug

Start Date: 5/1/2017

Required Date: 5/15/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3910-1P		Purchased	No			110	Each	0.0000	1	20			
D3910-1P									**				
Crosstube Lug													
D2423		Manufactured	No			110	f	361.1547	0.13	2.736842			
D2423									**				
Lug Extrusion													

20x SP17-516

DAS
13
9-89

MAY 18 2017

Location

Loc Qty

Loc Code

Metec

361.1546737

115229

64

127892

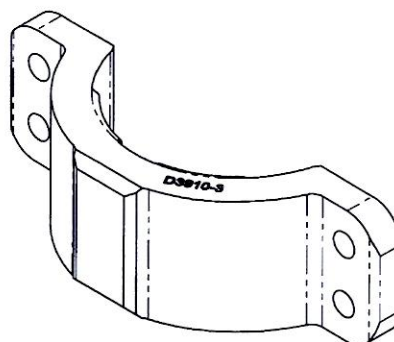
83.2745647

148835

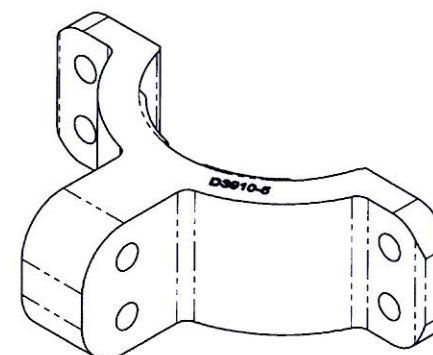
213.880109



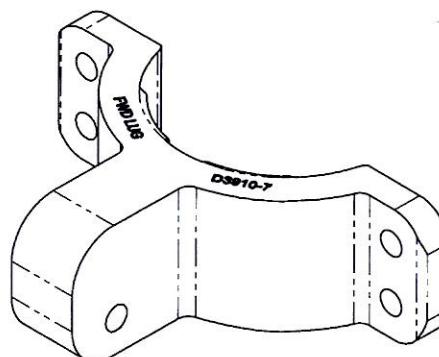
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005

RELEASED

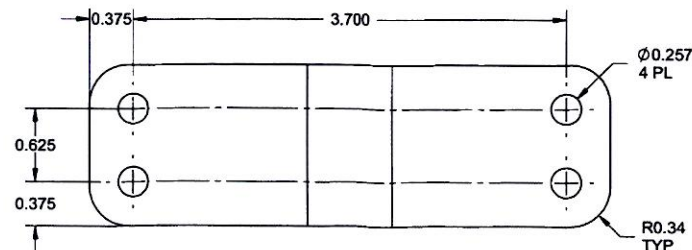
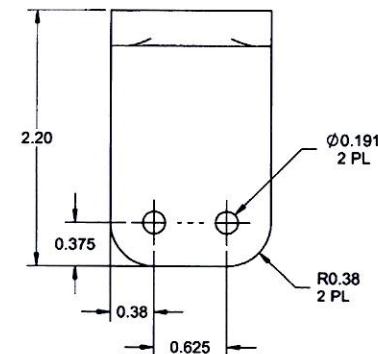
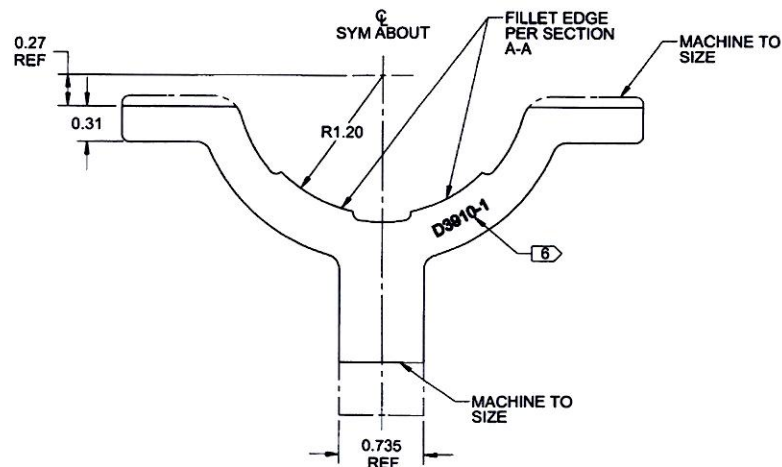
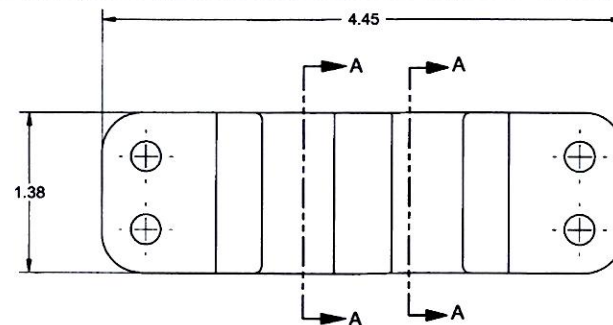
2014 JUN 05
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	4/	D3910	SHEET 1 OF 5
APPROVED	1/2	TITLE	SCALE
DE APPR.	5/	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

RELEASED
2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36153

Purchase Order Date 5/1/2017

PO Print Date 5/3/2017

Page Number 1 of 2

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

REVISED

Contact Name
Vendor Phone 613 678 3957

Ship To Contact
Ship To Phone
Ship Via: Dart Truck
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Chantal Lavoie

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3338-1P AS PER DWG D3338 REV. A B160521 ALODINE AND PAINT AS PER QSI 005	Mounting Lug	5/3/2017 No 5/3/2017		30.00 Each	\$20.60	\$618.00
	D3338-1P		5/18/2017		20.00 Each	\$20.60	\$412.00
			5/18/2017				
Line Total:							\$1,030.00
2	D3910-1P AS PER DWG D3910 REV. E B160539 ALODINE AND PAINT AS PER QSI 005	DAS 38 Crosstube Lug 9-89	5/18/2017 Yes 5/18/2017		20.00 Each	\$16.10	\$322.00
Line Total:							\$322.00

Note:

5/3/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21817
Date: May 08, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
--	---

Order No.: 36153	Sold By: Walz, Shigi (Regula)
Shipped By: your truck	Ship Date: May 08, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3338-1 Mounting Lug, as per drawing D3338 Rev.E Alodine and Paint as per QSI 005	Each	50		20
✓ D3910-1 Crosstube Lug, as per drawing D3910 Rev.A Alodine and Paint as per QSI 005	Each	20	20	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by

SP17-516

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3910-1	Lug Paint Batch # 21003 Material B148835	36153

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over the printed name.

Jan Norris

Vankleek Hill, May 8, 2017